

Appl. No. 09/889,495
Amendment filed August 24, 2005

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AMENDMENTS TO THE CLAIMS

1-10 (Cancelled)

11. (Previously Presented) A method for the mechanical working of metals and alloys which comprises conducting the mechanical working in the presence of an aqueous cooling lubricant having a pH of 6-10 and containing a phosphate ester of the formula

$R_1(\text{oxyalkylene})_n\text{OP(O)(X)(OH)}$ (I), or

$(\text{HO})_2(\text{O})\text{P}-(\text{oxyalkylene})_m-\text{OP(O)(OH)}_2$ (II),

where R_1 is an alkyl group with 1-12 carbon atoms, oxyalkylene is a group containing 2-4 carbon atoms, n is a number from 1-20, X is hydroxyl, $R_1\text{O}$ or $R_1(\text{oxyalkylene})_n\text{O}$, where R_1 , oxyalkylene and n have the meanings mentioned above, and m is a number from 4-40, or a salt thereof, and an alkenyl substituted succinic acid of the formula

$\text{HOOCCH(R}_2\text{)CH}_2\text{COOH}$ (III),

where R_2 is an alkenyl group with 4-10 carbon atoms, or a salt thereof, or a mixture of any of the compounds I, II and III.

12. (Previously Presented) The method according to claim 11 wherein R_1 in formula I contains 2-8 carbon atoms, the group $(\text{oxyalkylene})_n$ contains at least partially oxypropylene units and n is a number from 4-15.

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13. (Currently Amended) The method according to claim 12 wherein the ~~phosphate~~ phosphate ester of formula I is n-butyl-(OC₃H₆)₁₀OPO₃H₂.

14. (Previously Presented) The method according to claim 11, wherein the phosphate ester of formula II is



15. (Previously Presented) The method according to claim 11, wherein R₂ in formula III is selected from the group consisting of octenyl, decenyl, diisobutenyl and tripropenyl.

16. (Previously Presented) The method according to claim 15 wherein the phosphate ester has the formula I, in which R₁ contains 2-8 carbon atoms, the group(oxyalkylene)_n contains at least partially oxypropylene units and n is a number from 5-15.

17. (Previously Presented) The method according to claim 15 wherein the phosphate ester is



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18. (Previously Presented) The method according to claim 11 wherein the total amount of compounds I and II is from 0.2 to 5% by weight and the amount of compound III is from 0.2 to 5% by weight.

19. (Previously Presented) The method according to claim 16 wherein the total amount of compounds I and II is from 0.4 to 3% by weight and the amount of compound III is from to 3% by weight.

20. (Previously Presented) A concentrate, comprising
anionic compounds of the formula

$R_1(\text{oxyalkylene})_n\text{OP(O)(X)(OH)}$ (I), or

$(\text{HO})_2\text{P}(\text{oxyalkylene})_m\text{OP(O)(OH)}_2$ (II),

where R_1 is an alkyl group with 1-12 carbon atoms, oxyalkylene is a group containing 2-4 carbon atoms, n is a number from 1-20, X is hydroxyl, $R_1\text{O}$ or $R_1(\text{oxyalkylene})_n\text{O}$, where R_1 , oxyalkylene and n have the meanings mentioned above, and m is a number from 4-40, or a salt thereof, and an alkenyl substituted succinic acid of the formula

$\text{HOOCCH(R}_2\text{)CH}_2\text{COOH}$ (III),

where R_2 is an alkenyl group with 4-10 carbon atoms, or a salt thereof, or a mixture of any of the compounds I, II and III, which are present in a ~~an~~ total amount of 20-95% by weight and further containing additional corrosion

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inhibitors in an amount of 0-30% by weight, additional lubricants in an amount of 0-30% by weight, water in an amount 5-80% by weight, and other ingredients in an amount of 0-30% by weight, the weight ration between the compounds I and/or II and compound II being from 1:15 to 15:1.

21. (Previously Presented) The concentrate according to claim 20 wherein the anionic compounds I and II and II are present in a total amount of 50-90% by weight and further containing additional corrosion inhibitors in an amount of 0-15% by weight, additional lubricants in an amount of 0.15% by weight, water in an amount of 10-50% by weight, the other ingredients in an amount of 0-15%, the weight ration between the compounds I and/or II and compound III being from 1:5 to 5:1.

22. (Previously Presented) The concentrate according to claim 21 wherein the total amount of the additional corrosion inhibitors, the additional lubricants and the other ingredients is from 5 to 40% by weight.